

Date: Friday, 17/08/2007 11:21:25 AM  
User: Linda Lacelle

## Process Sheet

*Split into 80 07/08/26*

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLANGE PLATE
Job Number : 34086	
Estimate Number : 12173	
P.O. Number : <i>N/A</i>	Part Number : D34781
This Issue : 17/08/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3478 REV B
Prsht Rev. : <i>NC</i>	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 28569	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 11/09/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 10 Um: Each
Comment : Est Rev:A New Issue 06-02-03 JLM	
Est Rev:B As per Rev B 06-05-24 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.2205 sf(s)/Unit Total: 2.2050 sf(s)  
304/316 0.018 SHEET  
Batch: *M105445 IB 07-08-29*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
Cut as per Dwg D3478  
Dwg Rev: *B*  
Prog Rev: *B*

*IB 07-08-29*

*(P10)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*IB 07-08-29*

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*En 07/08/30 (x10) counted*

5.0	SMALL FAB 1-	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Form as per Dwg D3478 using D18848 A&B

*mf 07-10-17 (8)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: A Date: 07/10/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/30	# 20	one part has a small under cut in from the water jet R.C. Program error	<i>[Signature]</i> 05/10/12	Fix Program Scrap and replace And Destroy	<i>[Signature]</i> 07/08/30 SAP 07/08/30	<i>[Signature]</i> 07/08/30	<i>[Signature]</i>	<i>[Signature]</i> 07/08/30

NOTE: Date & initial all entries



Date: Friday, 17/08/2007 11:21:25 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE PLATE

Job Number: 34086

Part Number: D34781

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 07/10/18 (8)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF 07-10-19

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(8)  
D 07/10/19

Job Completion



h 07/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

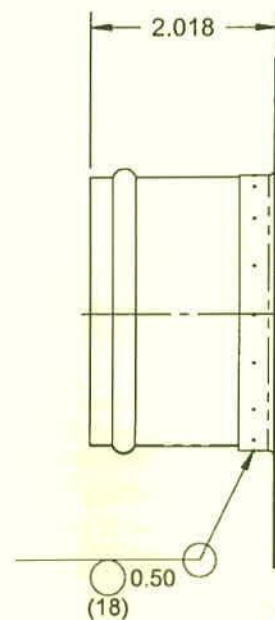
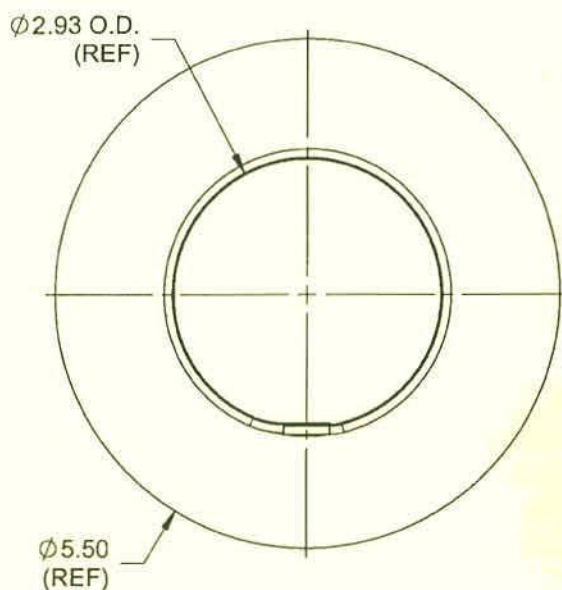
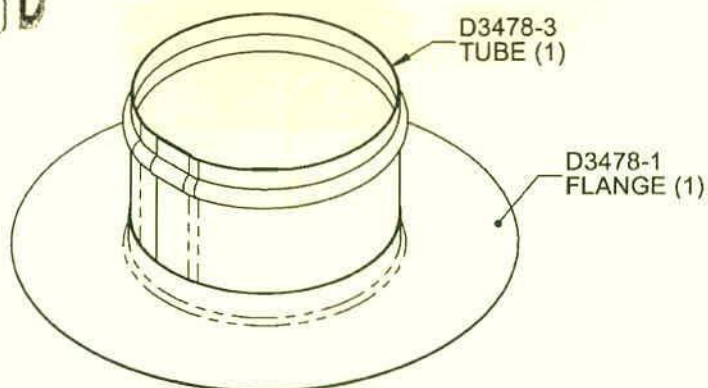
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

DESIGN B	DRAWN BY B	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. <b>D3478</b>	REV. B SHEET 1 OF 7
DATE <b>06.05.16</b>		TITLE <b>AIR INLET ADAPTER</b>	SCALE 1:2
A	05.12.08	NEW ISSUE	
B	06.05.16	REDESIGN D3478-5, ADD D3478-7, D3478-9S/-9	

**RELEASED**  
06-05-16 H**D3478-041 AIR INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3478-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3478-041	AIR INLET ADAPTER
1	D3478-1	FLANGE
1	D3478-3	TUBE

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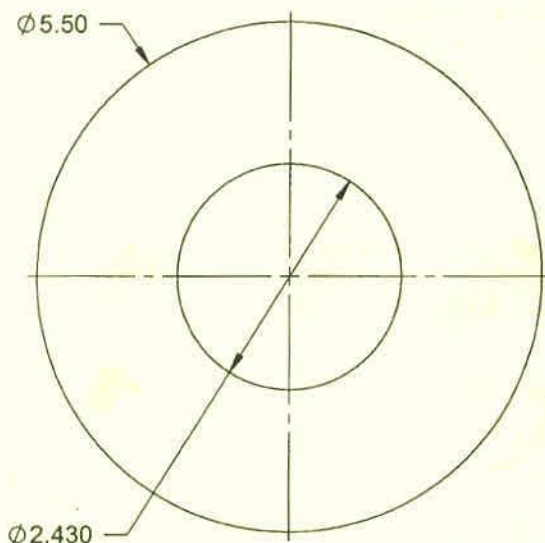
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WORK ORDER NO. 34086



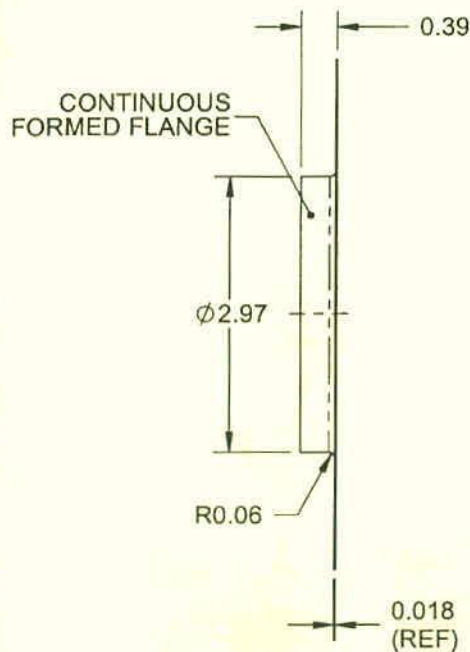


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3478	REV. B SHEET 2 OF 7
DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED  
06 05 16 #



**D3478-1F FLANGE  
FLAT PATTERN**



**D3478-1  
FLANGE**

**NOTES:**

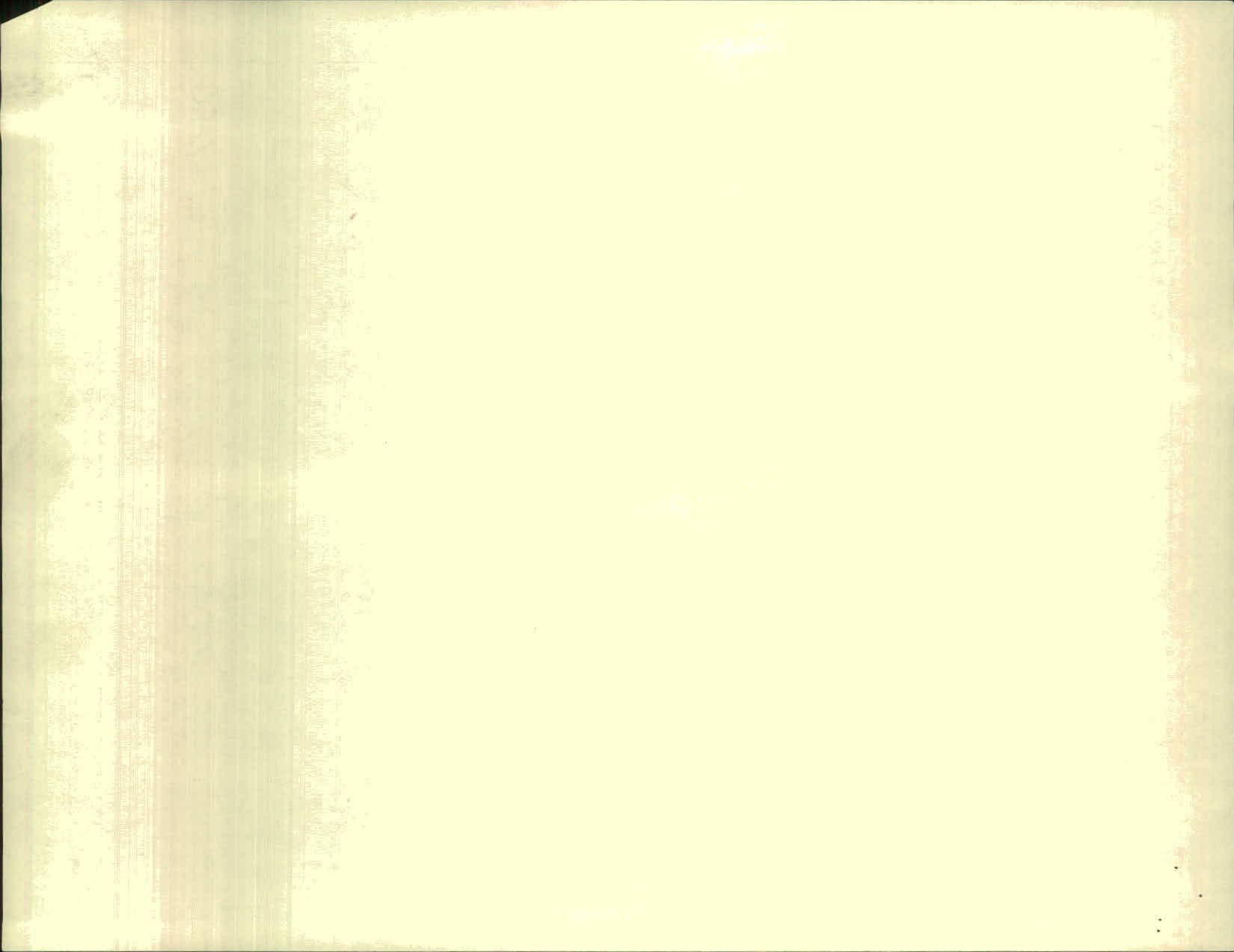
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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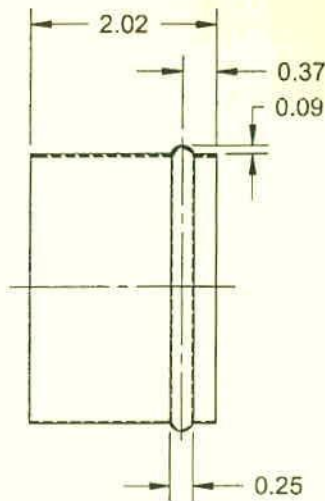




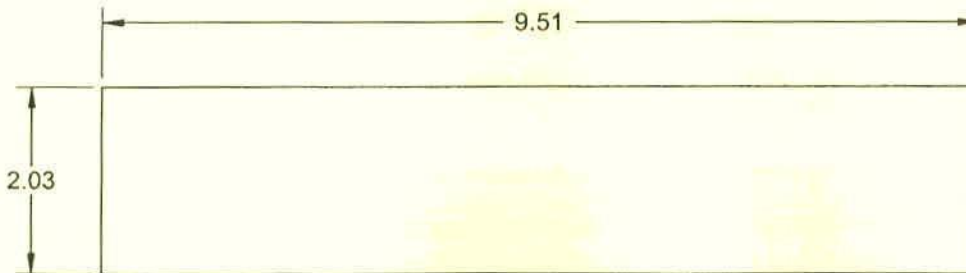
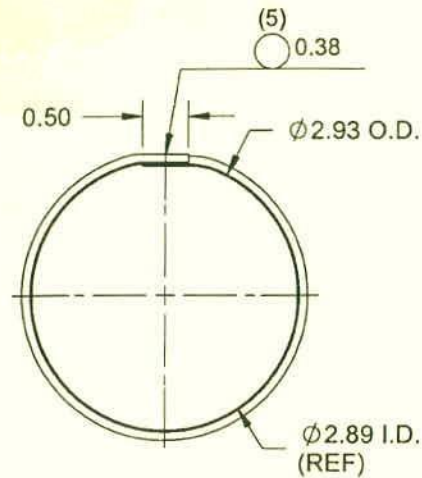


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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED  
06.05.16 *#*



**D3478-3 TUBE**



**D3478-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

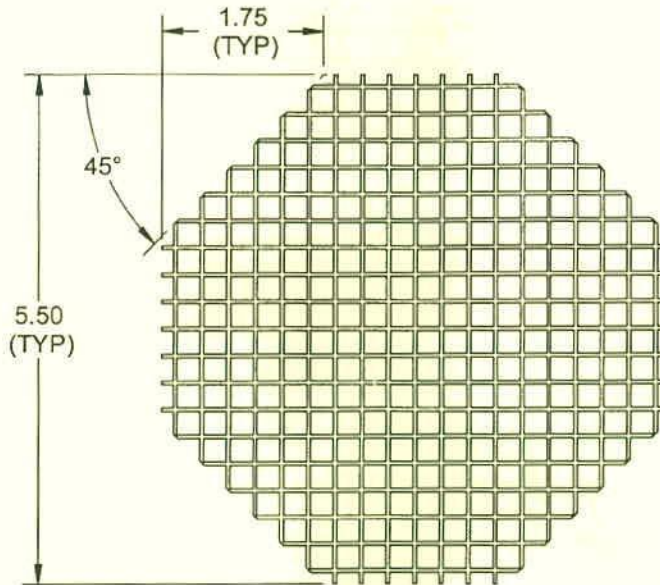
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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

**RELEASED**  
06.05.16 #**D3478-5 SCREEN****NOTES:**

- 1) MATERIAL: #4 MESH SCREEN, 0.203" OPENING,  $\phi$ 0.047" WIRE  
(REF. DART SPEC. M304MS4.203-.047)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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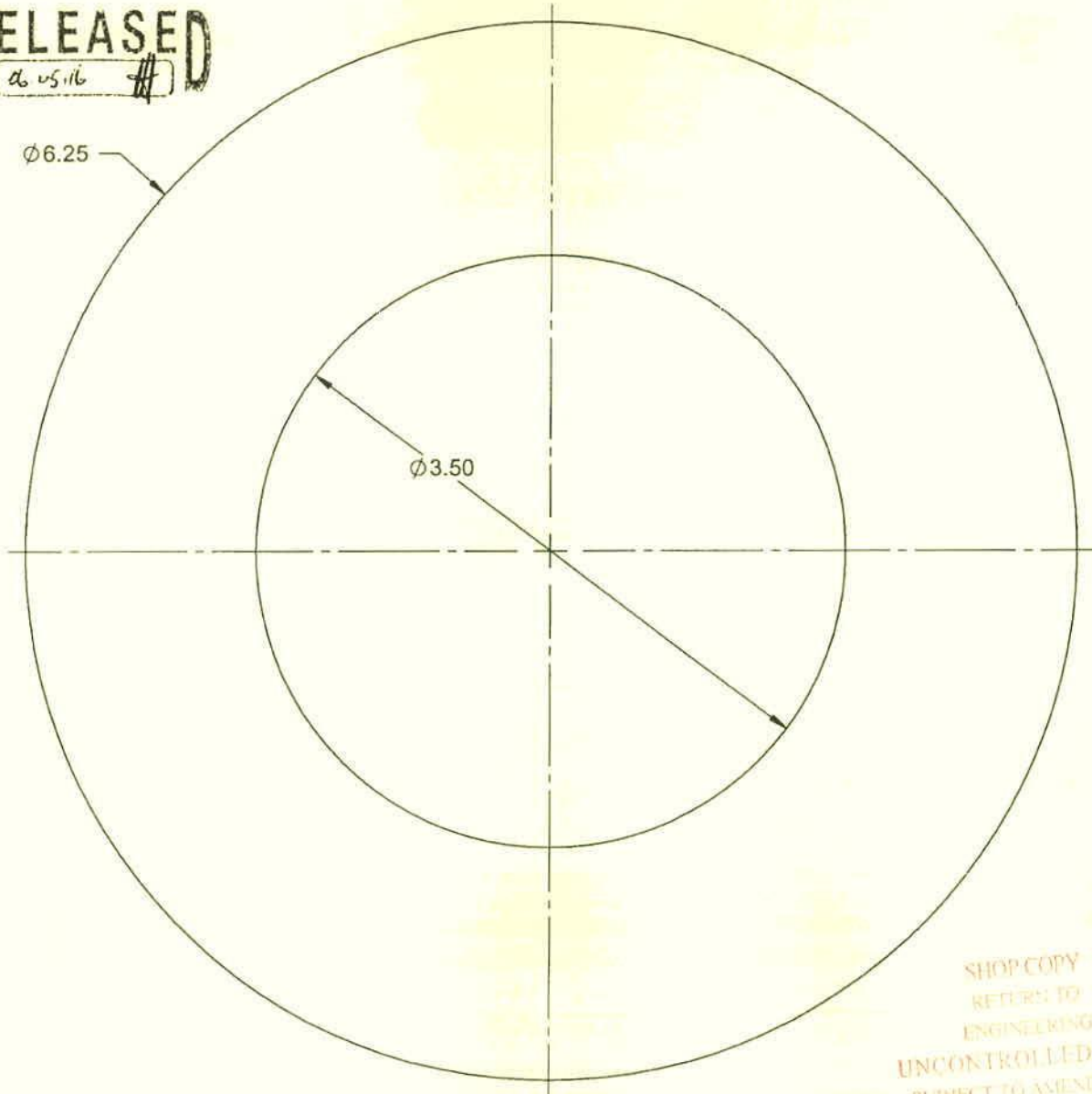




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DATE <b>06.05.16</b>		TITLE <b>AIR INLET ADAPTER</b>	SCALE 1:1

**RELEASED**  
*[Stamp]*

Ø6.25



Ø3.50

**D3478-7 INLET GASKET**

**NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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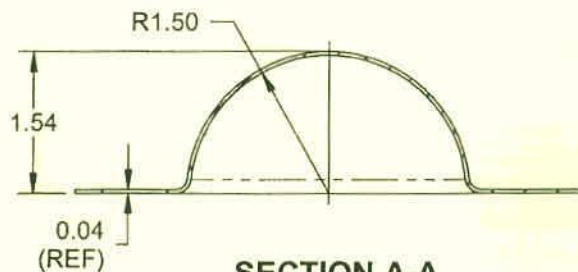
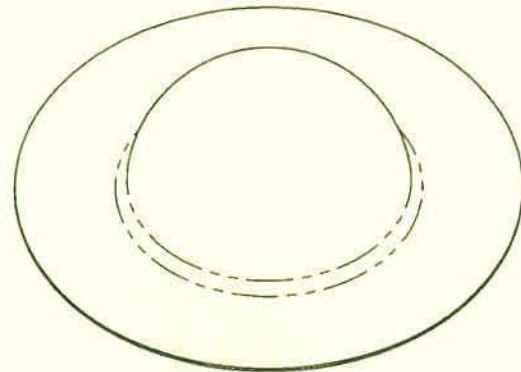
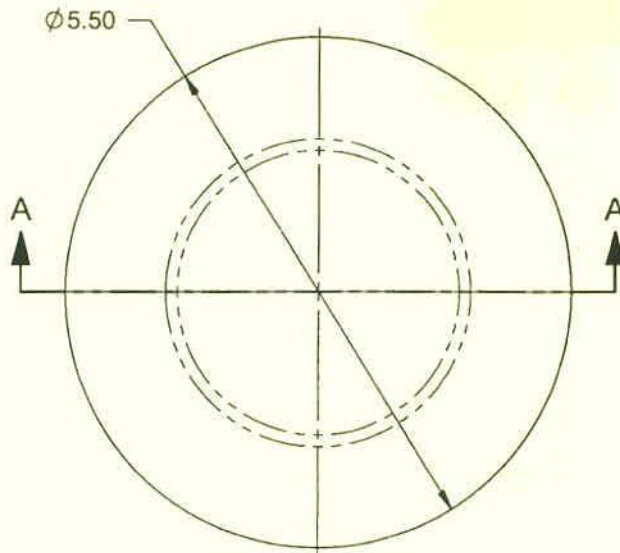
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DATE 06.05.16	TITLE AIR INLET ADAPTER		SCALE 1:2

**RELEASED**  
06-05-16**SECTION A-A****D3478-9S AIR INLET SCOOP, SPINNING DETAIL****NOTES:**

- 1) MATERIAL: 2024-0 ALUMINUM SHEET, 0.040" THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T0S.040)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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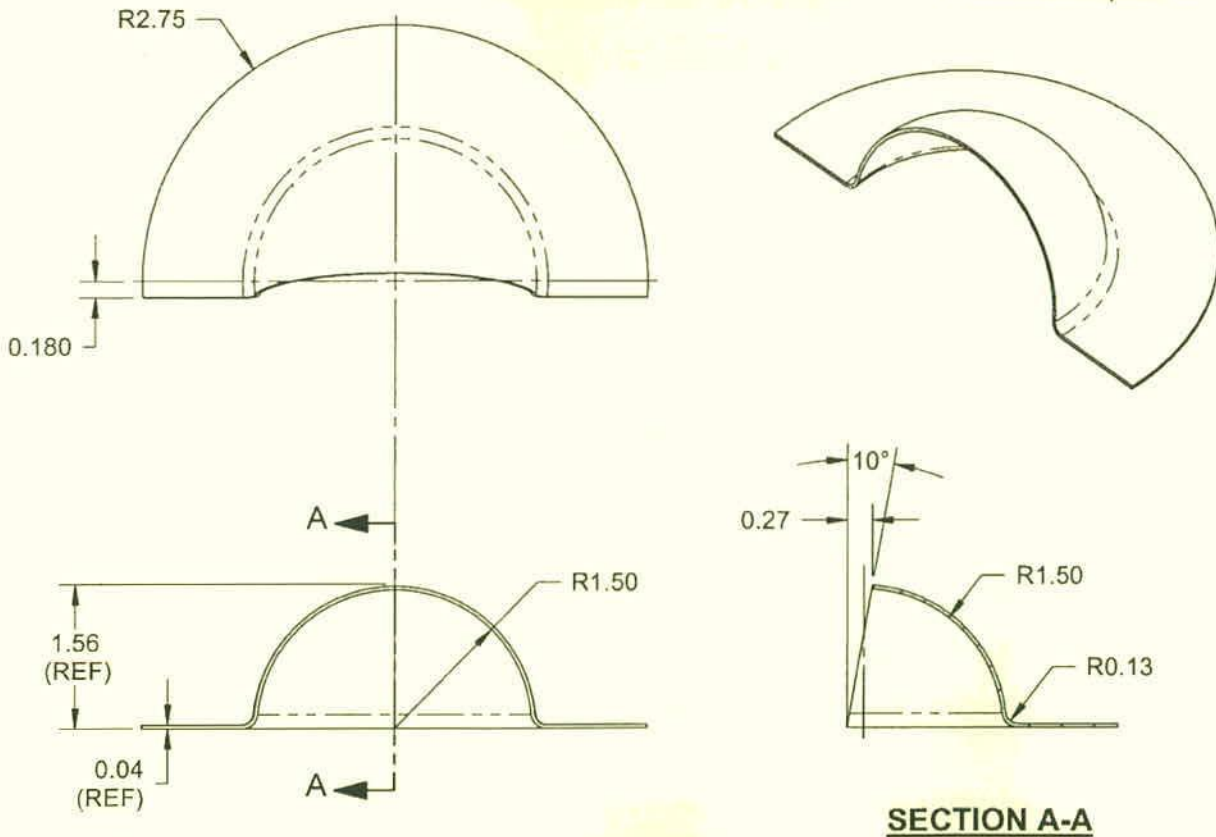
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CHECKED	APPROVED	DRAWING NO. D3478	REV. B SHEET 7 OF 7
DATE 06.05.16	TITLE AIR INLET ADAPTER		SCALE 1:2

**RELEASED**  
06.05.16**D3478-9 INLET SCOOP****NOTES:**

- 1) MATERIAL: MAKE FROM D3478-9S
- 2) IDENTIFY WITH DART P/N D3478-9 USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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